

**SPECIFICATION AMENDMENTS**

*Page 4, lines 17-19:*

Figure 3 is a schematic view of the deposition head of apparatus for forming the die of Figure 2 on the base of Figure 1, the schematic drawing including a feedback sensor; and

*Page 4, lines 20-22:*

Figure 4 is a schematic view of the laser spray nozzle of Figure 3 forming a melt-pool on the base of Figure 1 in the process of forming the die of Figure 2; and

*Page 5, lines 1-3:*

~~Figure 5 is a perspective view of a robotic manipulator for supporting the apparatus of Figure 3 and forming the working area of a large tool such as the die of Figure 2.~~

*Page 6, line 20 to page 7, line 8:*

In conventional direct metal deposition systems the dimensions of the parts being formed and the angles of the surfaces on which the layers are deposited are such that a simple three axis numerical control system can be used to move the workpiece relative to the deposition head. However, many of the tooling parts formed by the present invention will require special manipulation, and the present invention proposes that either the workpiece or the deposition head be supported in a robotic manipulator ~~50 of the type illustrated in Figure 5.~~ Preferably, the deposition delivery head is supported on the wrist of the robot and the tooling part is stationary. Such a system increases the flexibility of closed loop direct metal deposition even further to process stationary three-dimensional objects and add features enveloping the object through angles approximating 270 degrees.